

Work Order ID 62165

Monday, September 20, 2010 10:10:18 AM

Page 1

Item ID: D3684-049

Accept

Setup Start

Revision ID:

Stop

Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/1/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-9-20 Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

E510/09/20 (2)

E510/09/20 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	10/1/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 10/09/21		(2)			
130 Packaging Packaging	Identify as per dwg & Stock Location: GA Memo w/o 62168 62170	0.00 0.00		SB 10/09/21		(2)			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/09/21 MF 10-9-21

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Picklist Print

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Work Order ID: 62165

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	86.0000	2	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST351 86													
112314 8													
114761 11													
115392 47													
115594 20													
D3688-3 STUD		Manufactured	No			110	Each	8.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST076 5													
61371 5													
ST080 3													
51297 3													
D3689-1 SLEEVE		Manufactured	No			110	Each	13.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST082 13													
56335 1													
58634 12													

Eff 10/09/20

Eff 10/09/20

Eff 10/09/20

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Parent Item: D3684-049









Parent Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

D3691-1	Manufactured	No	110	Each	15.0000	1	2
							<i>EF 9/20/10</i>
STUD							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			ST082		15		
			58631		15		<i>2</i>
D3692-1	Manufactured	No	110	Each	349.0000	4	8
							<i>EF 9/20/10</i>
SPACER							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			ST082		349		
			51467		349		<i>8</i>
D3693-1	Manufactured	No	110	Each	40.0000	1	2
							<i>EF 9/20/10</i>
Rod End Bearing							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			ST082		40		
			50734		40		<i>2</i>
MS21043-3	Purchased	No	110	Each	2,643.000	2	4
							<i>EF 9/20/10</i>
Nut							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			FG		76		
			103691		76		
			ST301		2567		
			109147		4		
			111383		46		
			112314		2517		<i>4</i>

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Parent Item: D3684-049



Parent Item Name: AFT LEG ASS'Y

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 2.00

Required Qty: 2.00

NAS509-12C

Purchased

No

110

Each

46.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

46

112453

46

NAS509L12C

Purchased

No

110

Each

51.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

51

112314

41

112828

10

2
EP 10/09/20

2
EP 10/09/20

2

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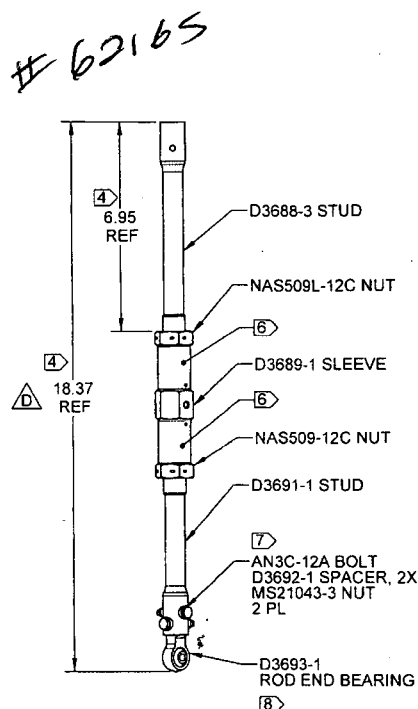
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3684	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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